

Date: Tuesday, 11/21/2006 1:35:16 PM  
 User: Kim Johnston

## Process Sheet

|                       |                                       |                  |                       |
|-----------------------|---------------------------------------|------------------|-----------------------|
| Customer              | : CU-DAR001 Dart Helicopters Services | Drawing Name     | : STRUT               |
| Job Number            | : 29618                               |                  |                       |
| Estimate Number       | : 12437                               |                  |                       |
| P.O. Number           | : N/A                                 | Part Number      | : D35181              |
| This Issue            | : 11/21/2006 S.O. No. : N/A           | Drawing Number   | : D3518 PRELIMINARY B |
| Prsht Rev.            | : NC                                  | Project Number   | : N/A                 |
| First Issue           | : N/A Type : MACHINED PARTS           | Drawing Revision | : A PRELIMINARY B     |
| Previous Run          | : 27983                               | Material         | : N/A                 |
| Written By            | : <u>                    </u>         | Due Date         | : 12/5/2006           |
| Checked & Approved By | : <u>                    </u>         | Qty:             | 12 Um: Each           |
| Comment               | : Est Rev:A New Issue 06-11-20 JLM    |                  |                       |

## Additional Product

Job Number:



|         |                       |               |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

|     |              |                     |
|-----|--------------|---------------------|
| 1.0 | M6061T6H0875 | 6061-T6 7/8" HexBar |
|-----|--------------|---------------------|



Comment: Qty.: 1.1550 f(s)/Unit Total: 13.8600 f(s)  
 6061-T6 7/8" HexBar  
 Batch: 1101694

MS/JS 06/11/22

|     |             |                    |
|-----|-------------|--------------------|
| 2.0 | LATHE CONV. | CONVENTIONAL LATHE |
|-----|-------------|--------------------|



Comment: CONVENTIONAL LATHE  
 Turn as per Dwg D3518,

1-Face to Length and Drill &amp; Tap.

MS/JS 06/11/22 8

|     |     |  |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MS/JS 06/11/22 8

|     |               |                              |
|-----|---------------|------------------------------|
| 4.0 | MILLING CONV. | CONVENTIONAL MILLING MACHINE |
|-----|---------------|------------------------------|



Comment: CONVENTIONAL MILLING MACHINE  
 Drill as per Dwg D3518.

1-Drill 2x .191" holes &amp; 1x .0625" hole

MS 06/11/25 8

|     |     |  |
|-----|-----|--|
| 5.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MS 06/11/25 8

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/12/04  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Tuesday, 11/21/2006 1:35:16 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 29618

Part Number: D35181

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

*ml 06/11/20*

*8*

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*Y/ am 06/11/30*

*x8*

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*fc 06/12/04*

*(8)*

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*SAN 06/12/02*

*(8)*

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*SAN 06/12/02*

*(8)*

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*06/12/04*

*(8)*

Job Completion



*06/12/04*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

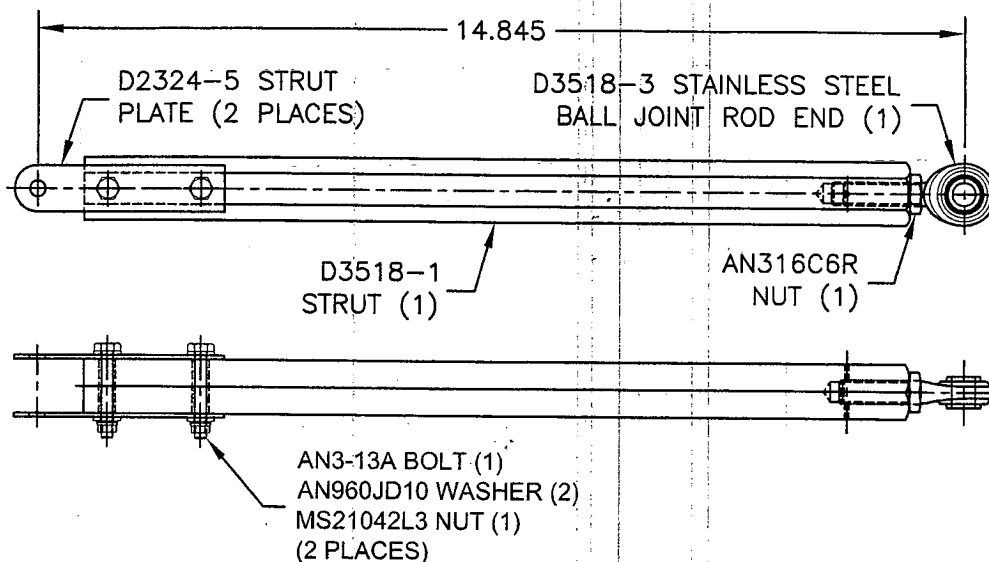
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 | Sign &<br>Date | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries



|                      |                                |   |                        |
|----------------------|--------------------------------|---|------------------------|
| DESIGN<br><i>B</i>   | DRAWN BY<br><i>B</i>           | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>PH</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D3518                              | REV. B<br>SHEET 1 OF 3 |
| DATE<br>06.10.23     |                                | TITLE<br>BASKET (A119) STRUT                      | SCALE<br>1:3           |
| A                    | 06.06.21                       | NEW ISSUE   |                        |
| B                    | 06.10.23                       | RE-DESIGN   |                        |



### D3518-041 STRUT ASSEMBLY

| QTY<br>-041 | Part Number | Description                        |
|-------------|-------------|------------------------------------|
| X           | D3518-041   | STRUT ASSEMBLY                     |
| 2           | D2324-5     | STRUT PLATE                        |
| 1           | D3518-1     | STRUT                              |
| 1           | D3518-3     | STAINLESS STEEL BALL JOINT ROD END |
| 2           | AN3-13A     | BOLT                               |
| 1           | AN316C6R    | NUT                                |
| 4           | AN960JD10   | WASHER                             |
| 2           | MS21042L3   | NUT                                |

#### NOTES:

- 1) IDENTIFY WITH DART P/N "D3518-041" USING FINE POINT PERMANENT INK MARKER.

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WORK ORDER

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06.11.17 *[Signature]*

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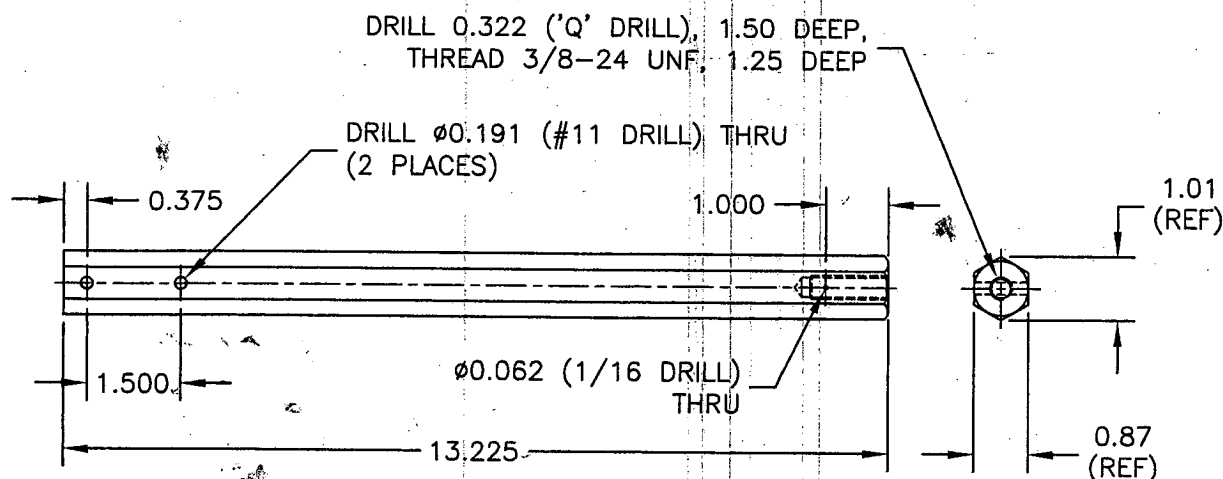
9

10

11



|                      |                                |   |                        |
|----------------------|--------------------------------|---|------------------------|
| DESIGN<br><i>B</i>   | DRAWN BY<br><i>B</i>           | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>PH</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D3518                              | REV. B<br>SHEET 2 OF 3 |
| DATE<br>06.10.23     |                                | TITLE<br>BASKET (A119) STRUT<br>SCALE<br>1:3      |                        |



### D3518-1 STRUT

#### NOTES:

- 1) MATERIAL: M6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM HEX BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF DART MATERIAL SPEC M6061T6H0.875)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES 0.005 TO 0.010 MAX

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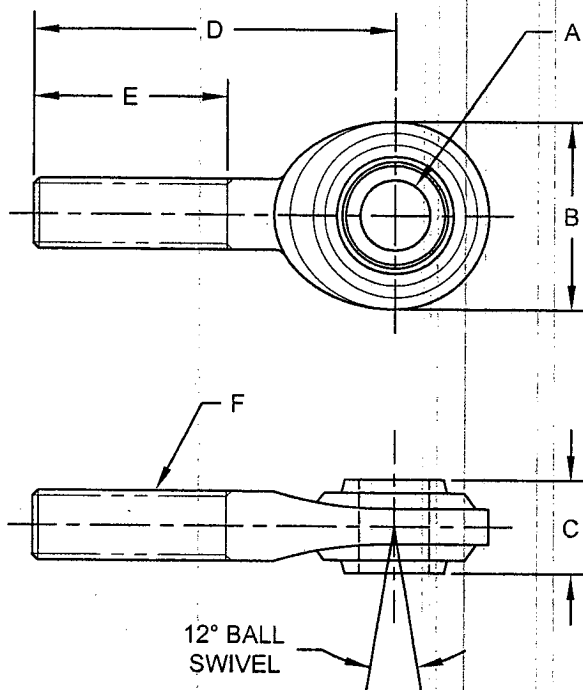
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| CHECKED<br><i>PH</i>         | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D3518                              | REV. B<br>SHEET 3 OF 3 |
| DATE<br>06.10.23             |                                | TITLE<br>BASKET (A119) STRUT                      | SCALE<br>1:1           |

## SPECIFICATION CONTROL DRAWING



| DART P/N | A     | B    | C    | D     | E    | F                 | LOAD* | POSSIBLE SUPPLIER             |
|----------|-------|------|------|-------|------|-------------------|-------|-------------------------------|
| D3518-3  | 0.375 | 1.00 | 0.50 | 1.938 | 1.25 | 3/8-24<br>UNF, RH | 4012  | McMASTER-CARR,<br>P/N 2458K14 |

\* Indicated load is Static Radial Load Capacity in lbs

### NOTES:

- 1) TYPE: MALE THREADED SHANK CARBON-FIBER-REINFORCED PLASTIC RACE BALL JOINT ROD END
- 2) MATERIAL: ZINC PLATED STEEL HOUSING BALL WITH PTFE LUBRICATED CARBON-FIBER-REINFORCED PLASTIC RACE.
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED

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06.11.17 *[Signature]*

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